



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBST1009-5
Job Sheet 174660



Ref: 175611

Part No: RBST1009-5

Job Qty: 25 ea

Part Name: Roller



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 3/20/18

Job Tracking No:

Due Date: 3/19/18

Created By: Chantal Lavoie

Type: SOLD

Description:

Note: DWG RBST1009 THRU 1020 Rev 7 IPP Rev A 18.03.01 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	25 Ea		3/19/18	0.00	0.00	Start Up Container		<i>AC 18/64/10</i>
100	Outsource	25 pcs		3/19/18			AFF001-VC	8	<i>CC 18-4-10 AC 18/64/10</i>
110	Packaging	25 pcs		3/19/18	0.00	0.00	Packaging2		<i>AC 18/64/10</i>
120	QC	25 pcs		3/19/18	0.00	0.00	QC6		<i>8081</i>
130	Packaging	25 pcs		3/19/18	0.00	0.00	Packaging3-2	<i>GA</i>	<i>APR 11 2018</i>
140	QC21-SA	25 Ea		3/19/18	0.00	0.00	QC21		<i>APR 11 2018</i>

Part Op 100 - ISSUE P/O: *039485* TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF
Descriptions: 89031009 ***NOTE*** One dowel pin makes 6 pcs.

DAS
21
9-20

APR 13 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
89031009	Plug and Pin Gauge	8.3750 Ea (.335 ea)	90-Start up Operation	<i>5059045</i> <i>5059658</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	89031009	8	47	0

8 X 5046388

Part Specifications

Specifications could not be found.

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Container No: S059647



Part: RBST1009-5

Job No: 174660

Serial No/Batch: S059647

Revision: 7

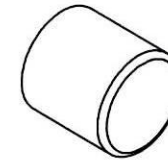
Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

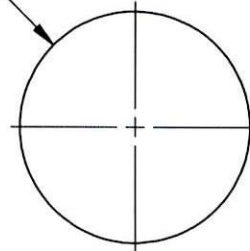
Date: 04/10/18

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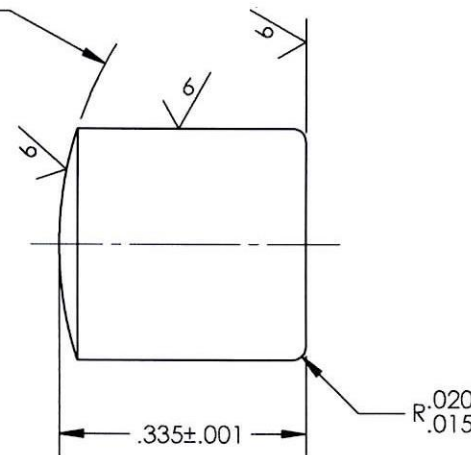
REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	



Ø .310
.309



SR .502
.498



TOOL
NUMBER

RBST1000

RBST1001

RBST1002

RBST1003

RBST1004

RBST1005

RBST1006

RBST1007

RBST1008

RBST1009

RBST1010

RBST1011

RBST1012

RBST1013

RBST1014

RBST1015

RBST1016

RBST1017

RBST1018

RBST1019

RBST1020

(-5)

ROLLER

DART AEROSPACE	
TITLE RBST1000 THRU 1020 DRILL PRESS TRI-ROLLER SWAGING TOOL	
DWG NO. SEE TABLE-5	REV 7
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 55-60	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125/✓
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: MACKOVJAK	SEE TABLE
SCALE 4:1	DATE 1/4/2008 SHEET 4 OF 9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039485**

Supplier: AFF001-VC
Affutage K.G. Inc.
11455 Philippe Panneton Ave.
Montreal
QC
H1E 4M1 Canada
Phone: 514 323 0192 514 323 6631
Fax: 514 323 6631

PO No: PO039485
PO Date: 4/2/18
Due Date: 4/10/18

Purchase Order
Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30

Freight Terms:

Special Comments:

REUSED

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	174660	RBST1009-5	Roller ISSUE P/O: _____ TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF 89031009 ***NOTE*** One dowel pin makes 6 pcs.	Firmed	4/10/18	25 pcs	0 pcs 25x	25 pcs	\$12.00/pcs AT 8/6/10	\$300.00
	175611			Firmed	4/10/18	5 pcs	0 pcs	5 pcs	\$12.00/pcs	\$60.00
Sub Total:						30	0	30		\$360.00

Grand Total: \$360.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 4/10/18 11:33 AM dart.lavoie.chantal

DAS
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9-89

AFFUTAGE K.G. INC.
K.G. GRINDING INC.

40 ans
Depuis 1975

**11455 Ave. Philippe Panneton
Montréal, Québec
Canada, H1E 4M1
Tél. : 514-323-0192
Fax : 514-323-6631**

Distributeur d'outils de coupe & Affutage sur mesure

Distributor of cutting tools & Custom tooling

BON DE LIVRAISON
DELIVERY SLIP

DATE: April-6-2018

DART AEROSPACE

73141

P.O. # 039485

[illegible]

REÇU EN BONNE CONDITION / RECEIVED IN GOOD ORDER

www.kggrinding.com • sales@kggrinding.com